

Work Order ID 131212

March-30-15 1:37:55 PM

131212

Page 1

Item ID: D4012-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cushion

Start Date: 3/30/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/31/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4012

C

100

0.00

100

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per folio FA889

Folio rev: _____

Dwg. rev: C

4 4 J.C.-L.
03/03/15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 4 J.C.-L.
03/07/15

PTO

NER last page

Work Order ID 131212

March-30-15 1:37:55 PM

131212

Page 2

Item ID: D4012-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cushion
 Start Date: 3/30/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/31/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				4	0		DAS 08 9-89
120	Memo	0.00		15/03/31					
QC									
Quality Control									

130	Identify as per dwg & Stock Location: _____	0.00							
130	Memo	0.00		Ship					DAS 6 9-89
Packaging									
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	0.00							
QC									
Quality Control									

MLJ 1503-31
 W 503.31

Picklist Print

March-30-15 1:37:55 PM

Page 1

Work Order ID: 131212

131212

Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 3/30/15

Required Date: 3/31/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue 09.10.28 DD verified by:JLM
revA as per dwg 09.11.18 DD verified by:JLM
as per dwg Rev.B DD verified by:JLM

IPP RevB:
IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	24.0000	0.37	2			
D4287-3 Uhmw U-Channel									**	J.C.-L			

Location

Loc Qty

Loc Code

ST479a

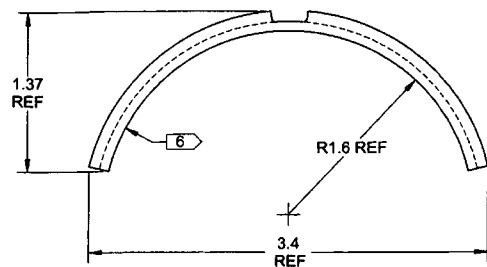
24

129618

24

1.5051

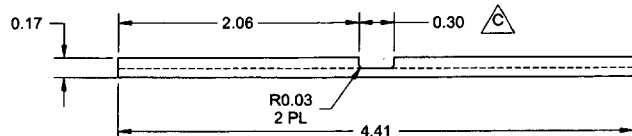
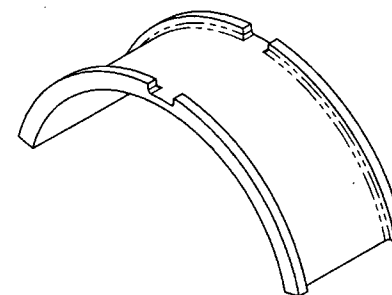
03/30



D4012-1 CUSHION
(MAKE FROM D4012-1F)

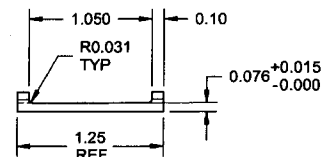
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)

*all
13212*



D4012-1F FLAT MACHINED STATE

0.09 REF
(MACHINE FLUSH TO 0.076 SURFACE)



- NOTES:
1) MATERIAL: MAKE FROM D4287-3
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

RELEASED

2015 MAR 26
4 EGN 15-532

C	ADD 0.30 NOTCH, 2 PL. ADD COLD FORM NOTE, REF DIMS FOR D4012-1 REASON: PAR 14-331, NCR 14-3521	DB	14.09.22
B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4012	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CUSHION	NTS
DATE	14.09.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA:

Date: 05/03/31



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/05/35

Work Order update only ☐

Work Order: <u>131 212</u> Part No. <u>D4012-1</u> NCR No. <u>15-4879</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/03/31	100	4	Dimension 0.17 is 0.125; Misread drawing RC OPERATOR ERROR.	A.P. 15.03.30	Scrap + replace D4237-3 B.12861-3 15' #3.20 (x4) #3.04	J.C.L. 15/03/31	15/03/31 DAS 08 9-89	DD 15-0331
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☒ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other